



TWIN CAM

Unmatched
PERFORMANCE
& DURABILITY



Serving Harley-Davidson dealers and motorcycle shops since 1983

www.jprecision.com



WORK SHEET

Shipping Address 2191, De la Province,
Longueuil, Qc, Canada, J4G 1R2

Phone: 450-647-6650

Fax: 450-647-1650

Dealer/Shop name _____ Date _____
Person to contact _____ Tel. _____

HEAD MODEL

M Twin Cam M EVO Sportster 883 to 1200 conversion M Milwaukee-Eight
M EVO Big Twin M EVO Sportster 1200 M Other (specify) _____

ENGINE SIZE

Engine size _____ Bore _____ Stroke _____

DESIRED

M Stage II M Stage IIB M Stages IIIB M Stages IVB Stages IV+ M Stages V
M Other (specify): _____

NOTE For all Stage IIB, IIIB and IVB, you must send us the two intake manifold flange to engrave them with a new "F" and "R".
Because you need to interchange the flanges to match the raised ports.
Not required for 2007 and up manifold with identical flanges.

PISTON MODEL With crankworks, we need the Piston weight in grams (inc. pin, clips and rings)

M Flat top M Domed M Reverse Dome Specify _____

DESIRED COMPRESSION

Ex.: 9.8 to 1 _____ cc's Specify _____

CAMSHAFT USED

Model _____ Lift _____ TDC lift _____

OUTSIDE ESTHETIC

M The heads will be shipped back as received M Other (specify) _____

HEAD WORK OPTIONS

- J Precision Titanium logo installed on Stage IIB and UP (no extra charge)..... M Yes M No
- Compression release valves installation: Machine heads for **manual** model & supply Machine..... M Yes M No
heads for **electric** model (machining only)..... M Yes M No
- Intake manifold supplied to be ported..... M Yes M No
- Pistons supplied to be machined for valve clearance..... M Yes M No
Extra(s) to repair (Ex.: Fix damage threads, weld crack, etc)

1 _____
2 _____
3 _____

WE MAKE YOU GO FASTER!



MACHINING SERVICES FOR TWIN CAM Engines (1999-up)

January 2024 – 2024/2025

HEAD: PORTING

Dealer
Price

Retail
Price

Piston to valve clearance must be checked with all performance head work.
Cast piston usually require more clearance. Do not forget to send them to us with the heads

655	STAGE II	(For stock casting from 88" to 107") Upgraded intake and exhaust port design and CNC ported. Not Included: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.900" intake valves and 1.585" exhaust valves	Call us	623.35
656	STAGE IIB	(For stock & aftermarket castings) Same as Stage II, except for the intake port which is redesigned and raised by welding to increase velocity; allowing for a crisper throttle response. Not included: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.900" intake valves and 1.585" exhaust valves	Call us	903.06
674	STAGE IIB	(For S/E 110) redesigned and raised by welding to increase velocity, allowing for a crisper throttle response. Not included: valve guides, valve seals, High Performance DOUBLE Springs kit, 2.100" intake valves and 1.650" exhaust valves	Call us	796.24
675	STAGE IIB	(For S/E 117 WET) Same as Stage II, except for the intake port which is redesigned and raised by welding to increase velocity; allowing for a crisper throttle response. Not included: valve guides, valve seals, High Performance DOUBLE Springs kit, 2.100" intake valves and 1.650" exhaust valves	Call us	956.53
657	STAGE IIIB	(For stock castings) Same as Stage IIB, Not included High Performance BEEHIVE Spring kit, 1.940" intake valves and 1.585" exhaust valves, intake valve seats.	Call us	1009.17
658	STAGE IVB	(For stock castings) Ultimate modification for your factory casting. Not included: valve guides, valve seals, High Performance BEEHIVE Spring kit, 1.990" intake valves and 1.585" exhaust valves, intake valve seats.	Call us	1062.56
658+	STAGE IV+	(For stock castings 117") Ultimate modification for your factory casting. Not Included: valve guides, valve seals, High Performance BEEHIVE Spring kit, 2.020" intake valves and 1.585" exhaust valves, intake valve seats.	Call us	1166.81
654	STAGE V	(For stock castings) We install 2.150" intake, 1.650" exhaust valves and modify the ports accordingly. Intake valve angle is modified, and rocker arm geometry is corrected. Labor only	Call us	1303.60
653	STAGE V	(For 120R, JIMS 131...) We install 2.150" intake, 1.650" exhaust valves and modify the ports accordingly. Intake valve angle is modified, and rocker arm geometry is corrected. Labor only	Call us	1390.03

HEAD: WORK OPTIONS

Dealer
Price

Retail
Price

650	Intake manifold porting (Carburator)	Call us	59.72
651	Screaming Eagle 50mm injection manifold porting (must be disassembled) except for the throttle plate	Call us	86.43
649	Intake manifold porting (Hurricane)	Call us	119.43
254	MACHINE 2 head for compression release valves (machining only)	Call us	104.00
255	MACHINE 2 heads for compression release valves (includes 1 set of AV&V compression release valves) JCR10B-2	Call us	182.28
257	MACHINE 2 heads for electric compression release valves (machining only)	Call us	172.85
607	PISTON valve pockets machined for valve clearance (2 pistons)	Call us	77.00
613	Check and adjust cc on Twin Cam / EVO / Sportster	Call us	73.85



MACHINING SERVICES FOR
TWIN CAM Engines (1999-up)

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CYLINDER HEADS

Dealer Price Retail Price

OVERALL REBUILD 2 HEADS

- Includes**
- Head gasket faces resurfaced
 - Valves centerless grinded
 - Set-up spring pressure & reassembly
 - Soda blast combustion chambers & ports
 - CNC seat job
 - Ultrasonic washed
- Not Included** -(4) new AV&V valve guides and valve seals

200	Overall rebuild 2 heads	Call us	411.72
201	Overall rebuild 2 heads + High Flow seat job	Call us	520.00
202	Overall rebuild 2 heads without guides replacement	Call us	368.13

HEAD: ESTHETIC

Dealer Price Retail Price

103	DISASSEMBLE & degrease 2 heads	Call us	48.72
105	SODA BLAST carbon out of 2 heads	Call us	48.72
114	HILITE fins (2 heads)	Call us	72.28
115	WELD & rebuild cooling fins	Call us	45.00 & UP
116	ULTRASONIC cleaning of 2 heads (ready for assembly)	Call us	56.57

HEAD: VALVE SEATS

Dealer Price Retail Price

204	CNC 3 ANGLE seat job (2 heads)	Call us	121.00
205	CNC HP seat job (2 heads)	Call us	143.50
210	MACHINE & install 1 valve seat (valve seat not included)	Call us	108.43
211	MACHINE & install 4 valve seats (valve seats not included)	Call us	271.85
213	WELD & repair valve seat receiver hole (valve seat not included)	Call us	115.00&UP

HEAD: VALVE GUIDES

Dealer Price Retail Price

218	REMOVE, install & fit 1 valve guide (labor only)	Call us	36.15
219	REMOVE, install & fit 4 valve guides (labor only)	Call us	72.28
223	WELD & REPAIR valve guide receiver hole to std (includes 1 new valve guide & valve seat)	Call us	192.00&UP
224	BORE CLEAN damaged valve guide receiver hole	Call us	103.72

HEAD: VALVES

Dealer Price Retail Price

231	CLEAN carbon out of 1 valve	Call us	12.57
228	RECONDITION 1 valve	Call us	12.57
229	RECONDITION 4 valves	Call us	38.00
227	CLEAN & RECONDITION 4 valves	Call us	75.50



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HEAD: RESURFACING

		Dealer Price	Retail Price
234	RESURFACE 2 heads .005" or less	Call us	84.85
235	RESURFACE 2 heads .006" & up	Call us	99.00
242	ANGLE MACHINE 2 combustion chambers & resurface gasket faces	Call us	180.72

HEAD: SPARK PLUGS

		Dealer Price	Retail Price
245	INSTALL 1 spark plug helicoil (helicoil included)	Call us	48.72
247	WELD & repair cracked spark plug hole (helicoil included) (2 heads)	Call us	216.85
250	MACHINE 2 heads dual plug	Call us	240.43
260	Remove broken exhaust bolt + install Helicoil	Call us	110.00

CYLINDERS: BORING & HONING

		Dealer Price	Retail Price
303	BORE, HONE & fit 2 cylinders with stress plates	Call us	171.28
304	SAME AS ABOVE but for 4" to 4 1/8" bore	Call us	198.00
305	SAME AS ABOVE but for 4 1/8" bore & up	Call us	223.15
307	HONE & FIT only, 2 cylinders with stress plates	Call us	103.72
308	BORE, HONE & fit 2 cylinders from 3.875" to 3.927" with stress plates	Call us	223.15
309	BORE, HONE & fit 2 cylinders from 1450cc. to 1550cc. with stress plates	Call us	289.15
310	BORE, HONE & fit 2 cylinders from 1450cc to 107" with stress plates	Call us	334.72

CYLINDERS: ESTHETIC

		Dealer Price	Retail Price
125	HILITE cooling fins on 2 cylinders	Call us	78.57
127	HILITE cooling fins & Paint on 2 cylinders	Call us	168.00

CYLINDERS: MISCELLANEOUS

		Dealer Price	Retail Price
318	REFACE 2 cylinders - lower decks	Call us	70.72
319	REFACE 2 cylinders - upper decks	Call us	86.43
320	REFACE 2 S&S cylinders - upper decks w/2 steps	Call us	111.57



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CRANK

		Dealer Price	Retail Price
404	CHECK alignment only & tig weld crank pin	Call us	125.72
405	DISASSEMBLE, inspect, reassemble & align crank & tig weld crank pin (for misaligned crank)	Call us	300.15
406	DISASSEMBLE, inspect, reassemble & align crank & tig weld crank pin (for misaligned crank) + Hone & Fit for new Rod Bearings (Sold separately)	Call us	423.15
407	SAME AS PREVIOUS + Dynamic balancing	Call us	644.28
408	SLEEVE damaged pinion shaft end (bushing section) (on already disassembled flywheels)	Call us	202.72
409	COMPLETE CRANK REBUILD (not included: new H-Beam rods, crank pin & bearing)	Call us	777.87
410	"B" to "A" PINION SHAFT CONVERSION (on already disassembled flywheels)	Call us	216.85
411	STRAIGHTEN TC 96" sprocket shaft	Call us	50.28
412	Rebuild S/E ROD	Call us	158.72
413	Small end conn. rod	Call us	166.57
414	Replace and ream 2 W Pin Bush	Call us	72.28
422	Grind solder of the crankpin	Call us	80.85
401	Remove, prepare and loctite pinion race	Call us	58.00
428	Weight compensation drilling for aluminum plugs	Call us	47.15
429	Relocate TC, Milwaukee-Eight balance gear	Call us	127.28

ENGINE CASES

		Dealer Price	Retail Price
505	BORE CASE for big bore cylinders (case must be assembled & torqued, unnecessary to remove cylinder studs)	Call us	257.72
506	TIMKEN RACE CONVERSION (Timken bearing not included)	Call us	194.85
508	SLEEVE one damaged cam bearing receiver hole	Call us	238.85
509	Crank case machining for cam clearance	Call us	92.72
532	Install Timken cups	Call us	48.72
520	Flexhone and fit (4) lifter bores	Call us	154.00
522	Sleeve (1) TC lifter bore	Call us	471.43
522-4	Sleeve (4) TC lifter bores	Call us	1571.43
536	Replace (2) cam bearing	Call us	55.00

MISCELLANEOUS

		Dealer Price	Retail Price
606	REFACE & polish 4 rocker arms	Call us	100.90
608	TC CAM Support plate bushing replacement (labor only)	Call us	59.72